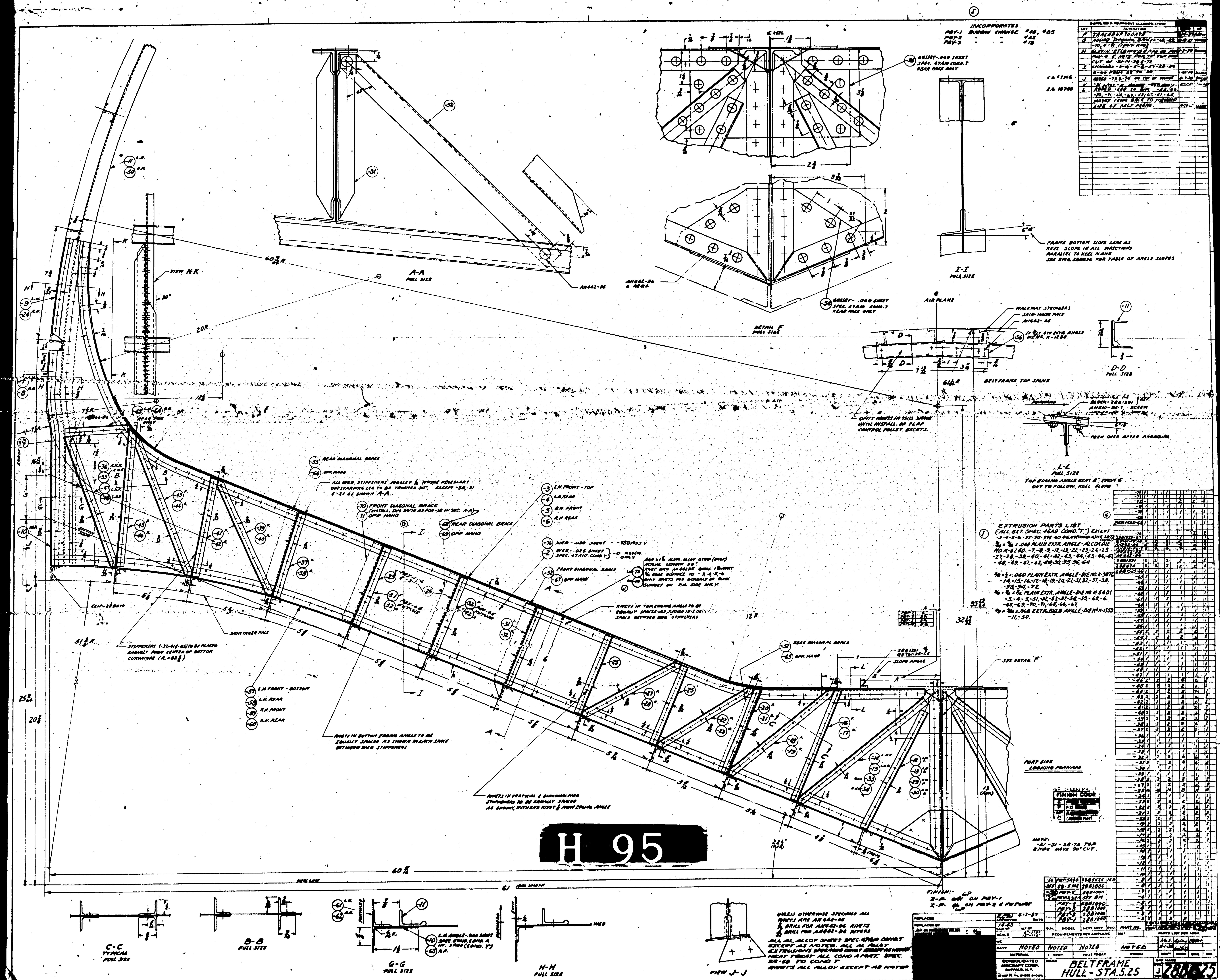

H 95
A-A
FULL SIZE
VIEW K-K
DETAIL F
FULL SIZE
I-I
FULL SIZE
D-D
FULL SIZE
L-L
FULL SIZE
TOP EDGING ANGLE BENT 8" FROM ℄ OUT TO FOLLOW KEEL SLOPE
FRAME BOTTOM SLOPE SAME AS KEEL SLOPE IN ALL DIRECTIONS PARALLEL TO KEEL PLANE
SEE DWG. 28B036 FOR TABLE OF ANGLE SLOPES
BELTFRAME TOP SPLICE
WALKWAY STRINGERS
OMIT RIVETS IN THIS SPACE UNTIL INSTALL. OF FLAP CONTROL PULLEY BRCKTS.
PEEN OVER AFTER ANGGLING
REAR DIAGONAL BRACE
OPP. HAND
ALL WEB STIFFENERS JOGGLED 1/8 WHERE NECESSARY
FRONT DIAGONAL BRACE
L.H. FRONT - TOP
L.H. REAR
R.H. FRONT
R.H. REAR
L.H. FRONT - BOTTOM
SKIN INNER FACE
CLIP-28B070
STIFFENERS (-37,-41,-45) TO BE PLACED RADIALLY FROM CENTER OF BOTTOM CURVATURE (R.=82 1/8)
RIVETS IN BOTTOM EDGING ANGLE TO BE EQUALLY SPACED AS SHOWN IN EACH SPACE BETWEEN WEB STIFFENERS
RIVETS IN TOP EDGING ANGLE TO BE EQUALLY SPACED AS SHOWN IN EACH SPACE BETWEEN WEB STIFFENERS
RIVETS IN VERTICAL & DIAGONAL WEB STIFFENERS TO BE EQUALLY SPACED AS SHOWN, WITH END RIVET 1/2 FROM EDGING ANGLE
SLOPE ANGLE
SEE DETAIL 'F'
PORT SIDE LOOKING FORWARD
KEEL LINE
EXTRUSION PARTS LIST
(ALL EXT. SPEC. 46A9 COND. "T") EXCEPT
-3-4-5-6-57-58-59-60 46A9 (COND A) HT. SR53 (COND T)
5/8 x 5/8 x .040 PLAIN EXTR. ANGLE-ALCOA DIE NO. K-6240. -7, -8, -9, -12, -13, -22, -23, -24, -25
-27, -28, -39, -40, -41, -42, -43, -44, -45, -46, -47
-48, -49, -61, -62, -29, -30, -35, -36, -64
-14, -15, -16, -17, -18, -19, -20, -21, -31, 32, -37, -38.
-33, -34, -72
PLAIN EXTR. ANGLE-DIE NO. K-5401
-3, -4, -5, -51, -52, -53, -57, -58, -59, -60, -6.
-68, -69, -70, -71, -65, -66, -67,
EXTR. BULB ANGLE-DIE NO. K-1559
-11, -50.
NOTE:
-21 -31 -38 -72 TOP ENDS HAVE 90° CUT.
FINISH:-
UNLESS OTHERWISE SPECIFIED ALL RIVETS ARE AN442-D8
DRILL FOR AN442-D6 RIVETS
DRILL FOR AN442-D8 RIVETS
ALL AL. ALLOY SHEET SPEC. 47A10 COND. T EXCEPT AS NOTED.
HEAT TREAT ALL COND A MAT. SPEC. SR-53 TO COND T
RIVETS ALL ALLOY EXCEPT AS NOTED
C-C
TYPICAL
FULL SIZE
B-B
FULL SIZE
G-G
FULL SIZE
H-H
FULL SIZE
VIEW J-J
REPLACES
REPLACED BY
[redacted]
APPROVED
DATE
CALC WT.
ACT WT
SCALE
NAVY
NOTED
MATERIAL
SPEC.
HEAT TREAT
FINISH
MODEL
NEXT ASSY
REQ.
PART NO.
REQUIREMENTS PER AIRPLANE
PARTS LIST PER ASSY.
DRAFT
CHECK
CONSOLIDATED AIRCRAFT CORP.
BUFFALO, N.Y.
NAME
BELTFRAME
HULL-STA.5.25
J
28B1525